

Work Order ID 67688

Tuesday, March 29, 2011 11:25:13 AM



Page 1

Item ID: D206-642-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *H*

Date: *11/03/27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	N								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

8/11/06/07

Per BG 11-4-26

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB *LC* *11/04/27*

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/11/06/07

CC

B67684

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67688

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Item ID: D206-642-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312 Location: <u>80</u> PPP Rev: <u>12</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/6/11 (1)

11/6/11

11-06-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M
 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8 u/b 17 D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				EG082				3					
				36550				1					
				44043				1					
				44044				1					
8 D206-648-013 GHW Modification	CHG002	Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG120				4					
				67296				4					
8 D2932-2 Saddle RH Out, 206		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST421				3					
				66381				3					
				ST428A				4					
				62080				4					

67084

67297 SP JB 11/04/27

62080

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-2

Manufactured No

110 Each

5.0000

1

1



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

2

66383

2

ST428

3

63585

3

D2938-2

Manufactured No

110 Each

4.0000

1

1



Saddle RH Out, 206

Location

Loc Qty

Loc Code

ST421

4

66039

2

66384

2

D2939-2

Manufactured No

110 Each

2.0000

1

1



Saddle RH In, 206

Location

Loc Qty

Loc Code

ST421

2

66385

2

AN3-41A

Purchased No

110 Each

368.0000

8

8



Bolt

Location

Loc Qty

Loc Code

ST354

369

112431

1

114941

68

115936

100

116191

200

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2652 Manufactured No

110 Each

364.0000

16

16

✓



Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

320

65049

32

66124

121

66934

167

66934

MS21042L3

Purchased No

110 Each

2,189.000

8

8

✓



Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

116540

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000

8

8

✓



Washer

AN5-10A

Purchased No

110 Each

152.0000

4

4

✓



Bolt

Location

Loc Qty

Loc Code

ST337

152

115700

2

116704

50

116924

50

117010

50

117010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No 110 Each 61.0000 4 4 ✓
Bolt

Location	Loc Qty	Loc Code
ST337	61	
115422	6	
116419	25	
116978	30	

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000 8 8 ✓
Washer

AN4-6A Purchased No 110 Each 1,079.000 12 12 ✓
Bolt

Location	Loc Qty	Loc Code
ST356	1079	
115936	200	
116191	79	
116400	400	
116924	400	

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000 24 24 ✓
Washer

MS21042L4 Purchased No 110 Each 3,324.000 12 12 ✓
Nut

Location	Loc Qty	Loc Code
ST300	3324	
116188	1324	
116823	2000	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

1.0000

1

1



Tow Ring



683389

Location

Loc Qty

Loc Code

ST420

6

66386

6

ST464

1

64071

1

D3456-1

Manufactured No

110 Each

62.0000

1

1



Washer



B68748

JB SP

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

55

64282

5

66848

50

D3457-1

Manufactured No

110 Each

24.0000

2

2



Washer



B67779

JB SP 11/04/27

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

14

66030

14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

737.0000

1

1

✓



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

697

116188

397

116549

300

116188

JB SP

AN4C5A

Purchased

No

110

Each

544.0000

1

1

✓



BOLT

Location

Loc Qty

Loc Code

FP-B

117

112243

117

ST345

427

112243

427

112243

JB SP

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

1

1

✓



washer

D3413-1

Manufactured

No

110

Each

48.0000

1

1

✓



Ring

Location

Loc Qty

Loc Code

ST420

22

62961

8

66387

14

ST473

26

53446

1

65294

10

66945

15

65294

SP JB 11/04/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 67688

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2712
Set Screw

Manufactured No

110 Each

571.0000

10

10

✓

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST012	252	
66955	252	
ST021	269	
61331	19	
65115	250	

D2934
Saddle Spacer

Manufactured No

110 Each

21.0000

2

2

✓

Location

Loc Qty

Loc Code

FG	6	
31929	6	
ST027	15	
66043	15	

D2935
Saddle Spacer

Manufactured No

110 Each

80.0000

2

2

✓

Location

Loc Qty

Loc Code

ST027	80	
63558	9	
66564	71	

JB

65115
B67585 X1
JB

66043 X1
2
JB 11/04/27

66564

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D206-642
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4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE
⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N
Date: 09.09.09

